

Date: Monday, 28/04/2008 8:13:27 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: WEAR PLATE		
Job Number	: 38811			Part Number	: D2348		
Estimate Number	: 11231			Drawing Number	: D2348 REV B2		
P.O. Number	:			Project Number	: N/A		
This Issue	: 28/04/2008	S.O. No.	:	Drawing Revision	: B2		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 15/05/2008		
Previous Run	: 31919			Qty:	50 Um: Each		
Written By				<i>SC</i>			
Checked & Approved By	: <u>JUL 08.4.28</u>						
Comment	Est Rev A	Removed from 9 Digit	05-12-05	JLM			
	Est Rev:B	Now on Waterjet	06-07-03	JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S063	6061-T6 .063 Sheet
Comment: Qty.: 0.0208 sf(s)/Unit Total : 1.0395 sf(s) Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Batch: <u>105285</u> <u>RB 8-4-30</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2348 Dwg Rev: <u>B2</u> <u>RB 8-4-30</u> Prog Rev: <u>B2</u> 2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>RB 8-4-30</u>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK <i>route</i> <u>Co8/05/05</u> <u>(CST)</u>
Comment: SECOND CHECK		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <i>see Step #2.2 Co8/05/05</i>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 8:13:27 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR PLATE

Job Number: 38811

Part Number: D2348

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



create

Comment: INSPECT WORK TO CURRENT STEP

7.0 OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting PURCHASING

Issue P/O: _____

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

INSPECT CERTS

10.0 FE832EF

PEM Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick: _____

Qty Part Number Description Batch

4 FE832EF

PEM Insert

101634 22X

107897 X198+
107897 ~~XX~~

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Insert as per Dwg D2348

INSPECT WORK TO CURRENT STEP

CBox/05/20

55

PTU



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DZ348 PAR #: N/A Fault Category: Prod/Finishing NCR: Yes No DQA: JP Date: 28/05/29
 QA: N/C Closed: JP Date: 28/05/29

NCR: 38811		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/05/22	11.0	Inserts were pressed into the parts, and the parts were not anodized. Steps 7.0, 8.0 & 9.0 were not completed. R.C: Employee continued with the parts, when previous steps of work was not completed, lack of attention to the process.	JP 08/05/22	- Scrap & destroy all parts. - no replace. - Ensure to double check W.O for completeness before starting a step, and continuing the process.	JP 08/05/29	SBS 08/05/29	JP 08/05/22	JP 08.05.22

NOTE: Date & initial all entries

Date: Monday, 28/04/2008 8:13:27 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEAR PLATE

Job Number: 38811

Part Number: D2348

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

14.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38811
Description: Wear Plate	Part Number:	D2348
Inspection Dwg: D2348 Rev: B2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

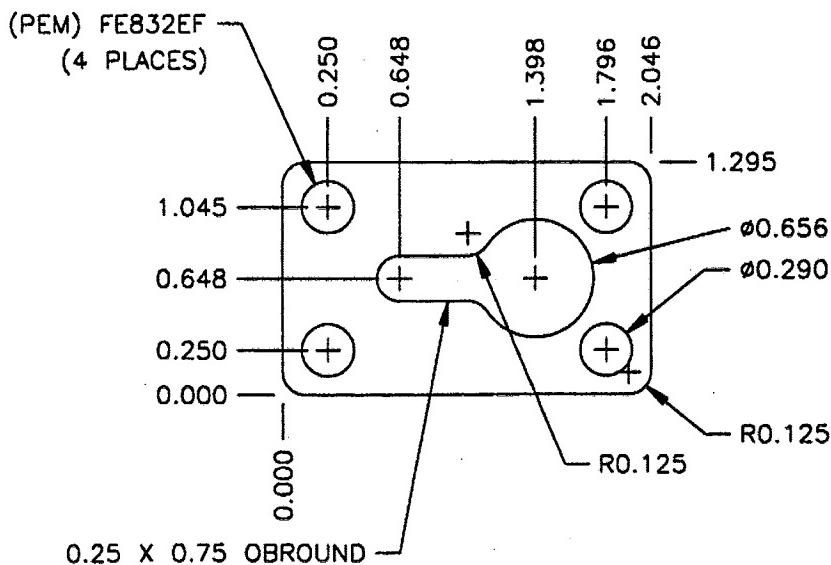
X First Article Prototype

Measured by:	B	Audited by:		Prototype Approval:	N/A
Date:	8-4-23	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	P/O D350-616-015	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>

DART

DESIGN B. WILLIAMS	DRAWN BY B. WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>J</i>	DRAWING NO. D2348	REV. B SHEET 1 OF 1
DATE 95:01:20		TITLE WEAR PLATE	SCALE 1:1
B	95:02:20	CHANGED PEM INSERT TO 8-32	
Bi	00.03.07	CHANGE TO AISI 304/316 MATERIAL	
B2	# RF 02.02.21	CHANGE BACK TO 6061-T6	

RELEASED
 97/04/22 DS


- NOTES:
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 (M6061T6S)
 - 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/II/IC/II/IB CLASS 2
 - 3) INSTALL FE832 EF INSERTS AFTER ANODIZING
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER DART QSE 01B UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38811

AISI 304/316 SS

MATERIAL: ~~6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK~~
AFTER ANODIZING INSTALL (PEM FE832EF) 4 PLACES

00.03.07